

Date: Monday, 22/09/2008 10:36:22 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLUG
Job Number	: 42153		
Estimate Number	: 10512		
P.O. Number	:	Part Number	: D26511
This Issue	: 22/09/2008 S.O. No. :	Drawing Number	: D2651 REV. B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 41971	Material	:
Written By	:	Due Date	: 29/09/2008 Qty: 200 Um: Each
Checked & Approved By	: <u>JUD 08.09.22</u>		
Comment	: Est: A 02.04.15 New Issue NG Est: B 05.12.12 added deburr EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0500	6061-T6 Round Bar .500"
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0.046
~~0.0435~~
 9.2

8.4
 9.2



Comment: Qty.: 0.0421 f(s)/Unit Total: 8.4210 f(s)

Material: 6061-T6 (QQ-A-225/8) 0.500" Dia
 (M6061T6R0500)

Batch: M107676

SA 08/09/22

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Turn as per Folio FA219 and Dwg D2651

2- Deburr

SA 08/09/22

(210)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 08/09/22

(210)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

mL 08/09/22

(210)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr ias per dwg D2651

N/A 08/09/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 22/09/2008 10:36:22 AM
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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(210X)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-L

08/09/26

7.0

POWDER COATING

POWDER COATING



(210X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

(Only larger section necessary)

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:40
320 OF
8:10

M-L

08/09/27

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(210)

Comment: INSPECT POWDER COAT

FZ

08/09/29

9.0

PACKAGING 1

PACKAGING RESOURCE #1



(210)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-A

FZ 08/09/29

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/30

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-30

W/O:		WORK ORDER CHANGES					
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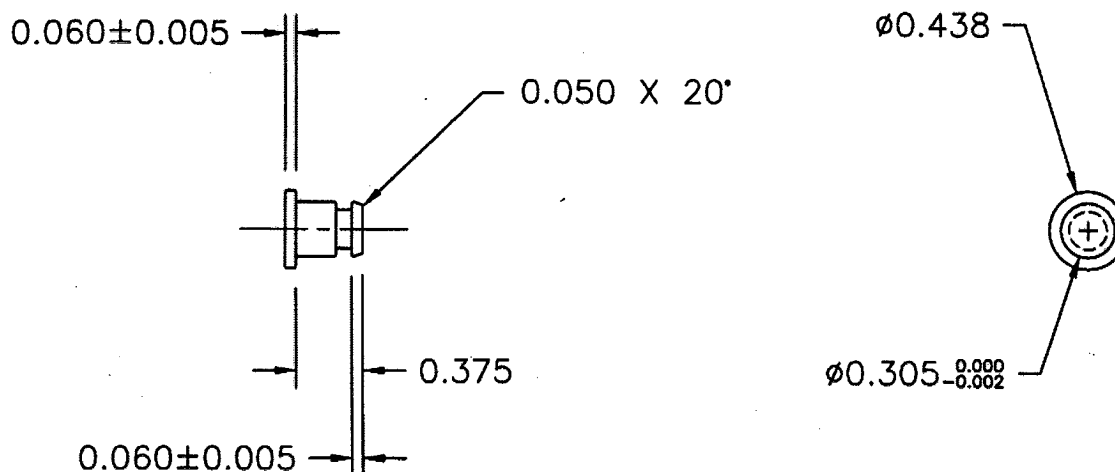


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2651	REV. B SHEET 1 OF 1
DATE 03.12.19		TITLE PLUG	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

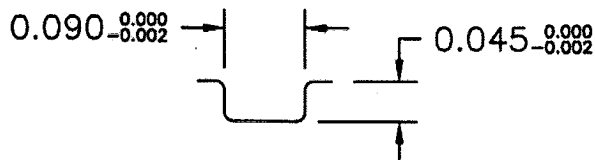
RELEASED

03.12.19

D2651-1 PLUG:



GROOVE DETAIL (SCALE 5:1)



D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER
3/16 ID, 5/16 OD, 1/16 WIDTH
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42153

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